

Date: Tuesday, 07/04/2009 10:22:34 AM
 User: Julie Dawson

Process Sheet

SPLIT-2.

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 46986 - 2
 Estimate Number : 11217
 P.O. Number :
 This Issue : 07/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 46697
 Drawing Name : GHW LUG
 Part Number : D34041
 Drawing Number : D3404 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 24/04/2009 Qty: ~~40~~ 43 Um: Each
 Written By :
 Checked & Approved By : JLD 09.04.01
 Comment : Est Rev: A 05.09.01 New issue KJ/JLM
 Est rev B 09.01.28 new geometry rev.C EC verified by: DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304B0750X2500 304 BAR .750 X 2.50



Comment: Qty.: 0.2406 f(s)/Unit Total : 9.6222 f(s)
 Material: AISI 304/316 SS Bar 2.50" x 0.75" thick
 (M304B0.750x02.500)
 Identify for D3404-1
 Batch: M110727

M105302 X 19

JLD 09/04/16

43
42

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank: 2.750" long

JLD 09/04/16

42

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA555 and Dwg D3404
 Dwg Rev: C Folio Rev: C

2-Deburr

35

PTO

JLD 09/04/20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE








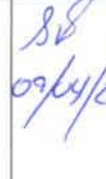

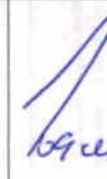
35

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLD 09/04/21 JLD 09/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3404-1 PAR #: N/A Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/23
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46986</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/20	3.0	One part shift when machining process on the first operation. The L66 of .510 ^{+0.08} / _{-0.001} came of center with the part.		Replace B# <u>M110777</u> Qty #1	 09/04/20	S 07/04/23	 09/04/23	 09/04/21
		R.C. operator error do not tight vise properly			 09/04/20	S 09/04/23	 09/04/23	 09/04/21

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:22:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW LUG

Job Number: 46986

Part Number: D34041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

N.A

09/04/22

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

WA

09/04/22

(30)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/23

MF

09-04-22

Job Completion



D3404-1 GHW LUG

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WORK ORDER NO. 108810

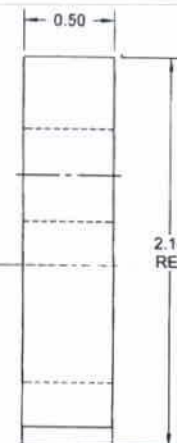
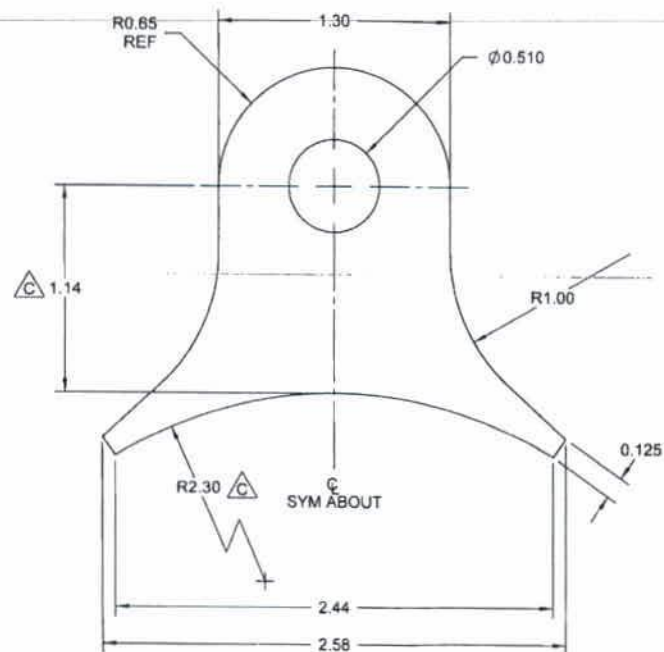
RELEASED
08/12/11 NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
DATE	08.12.02	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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RELEASED
08/12/76

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3404	REV. C SHEET 2 OF 2
MFG. APPR.	<i>[Signature]</i>	TITLE GHW LUG	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.12.02		